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D2278
Job Sheet 212740



Part No: D2278

Job Qty: 12¹³ pcs

Part Name: Step Leg



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/2/20

Job Tracking No:

Due Date: 9/4/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev C New flat pattern 08.01.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs			0.01	1.35	Waterjet - Flow		ac 20/09/02
110	QC 2	12 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		ac 20/09/02
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
120 QC 8	12 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
130 Handfinish - 1-1 Chemical- B4B	12 pcs	0.00 0.32	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	

SEP 02 2020 **DAS**
40
0.00

140 QC 7	12 pcs	0.00 0.00	Handfinish - 1 - 22 - B4B	
			QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	DAS
			QC 7 - 83	81
			QC 7 - 82	9-89
			QC 7 - 87	
				SEP 03 2020
150 Packaging 3-1 - Stock - B4B	12 pcs 13 pcs mld	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	DAS
			Packaging 3 - 7 - B4B	28
			Packaging 3 - 8 - B4B	9-89
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	SEP 03 2020
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	

		Packaging 3 - 24 - B4B		
		Packaging 3 - 25 - B4B		
		Packaging 3 - 26 - B4B		
		Packaging 3 - 27 - B4B		
		Packaging 3 - 28 - B4B		
		Packaging 3 - 29 - B4B		
		Packaging 3 - 30 - B4B		
		Packaging 3 - 31 - B4B		
		Packaging 3 - 32 - B4B		
		Packaging 3 - 33 - B4B		
		Packaging 3 - 34 - B4B		
		Packaging 3 - 35 - B4B		
		Packaging 3 - 36 - B4B		
		Packaging 3 - 37 - B4B		
160 QC 21 - SA	12 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 9	SEP 13 2026
			QC 21 - SA - 77	70
			QC 21 - SA - 28	89

SEP 03 2020
BAS 70
9-89

Part Op 100 - 1-Cut as per Dwg D2278
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	11.7780 sf (.9815 ea)	100-Waterjet - Flow - 1	S232779

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	12	172	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Leg	0.354Inches ± 0.010	0.364 0.344		
2	Leg	0.354Inches ± 0.010	0.364 0.344		
3	Leg	16.460Inches ± 0.030	16.490 16.430		
4	Leg	0.128Inches + 0.005 - 0.000	0.133 0.128		
5	Leg	0.354Inches ± 0.030	0.384 0.324	Radius	
6	Leg	2.000Inches ± 0.030	2.030 1.970		
7	Leg	4.740Inches ± 0.030	4.770 4.710		
8	Leg	8.460Inches ± 0.030	8.490 8.430		
9	Leg	0.213Inches ± 0.010	0.223 0.203		
10	Leg	0.750Inches ± 0.010	0.760 0.740		
11	Leg	0.080Inches ± 0.010	0.090 0.070	thick	



Container No: S298151



Part: D2278

Job No: 212740

Serial No/Batch: S298151

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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